Work Order 1 March-28-13 12:55		3			*(991	43*							Page	1
Revision ID:	021-9 shing				Accept	,	*N900	040	100)* s	Setup	Start Stop	171.	S1* S2*	
Start Date: 3/2 Required Date: 3/2 Reference:		tart Qty: leq'd Qty	1	*60°			Cust Item II Customer:	D:							
Approvais: Pi	rocess Plan:		/	Date:	Tooling: SPC (Y/N	N):		ite:		R	lun	Start Stop	*NI *N	R1* R2*	
Sequence ID/ Work Center ID		peration escription	1		Set Up Run H		Tool ID	Tool #	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp	
Draw Nbr	Revisio	n Nbr													
D4021	В		1												
*100 *100* Hardinge Hardinge CNC Lathe Sm	all	T D F	OWG REV:_ OLIO REV:	ER FOLIO FA 868 ANI D N/A E TO .375" MAX OD		(0	13/04/0	3		60		Ø			-
*110 *11 0 * oc	· Q		parts off ma	chine FAI/FAIB	0.00	₽ <u>0</u>	13/01/0	03		60	<u>_</u>	<u> </u>			:-

Quality Control

										DQA:	Date:	
NCR: Y	es / No				WORK ORDER NON-C	CON	NFORM	MANCE / UPDA		QA Closed:	Date:	
Work Orda					DISPOSITION		·	The second second second second	AGAINST DEF	PARTMENT	PROCESS	The state of the s
Part No. NCR No.				Scrap Machining Small Fa Use-as-is Thermoforming Finishin		Crosstube Small Fab Finishing omposite	Prod. Eng. Coor Rec/Store/Packaging		Engineering Quality Other			
Root				Descri	ption of work order update	1	nitial	Action		Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Descripti	ion	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling		Į		·		1						
Operator [ĺ	1 1									
Material [Ì						1
Setup												
Other												
Process		ļ										
Supplier												
Training [
Unapproved									;			
					F.	AUL	T CATE	GORY				
Landir	ng Gear				General			•		Ì	_	-
ļ	Bending				Bend		Grain		<u> </u>	Ovalized	·	Pressure/Forced
ļ	Centre N	ot Conce	ntric to (o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld
	Crushed/	Crimped			Burrs		ł	ions Incomplete/Uncl	lear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination	L_	Mainte	enance		Part Moved		
	Heat Trea	at			Countersink		Mislabe	eled		Positioned V		_
	Inspectio	n Strip in	Tube		Cut Too Short		Misread	d		Power Loss/	Surge	Other
Γ	Ripples in	n Bend			Drill Holes		Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Orden		9143	*0	9143*
Item ID: Revision ID:	D4021-9		Accept	*N900040100*
Item Name: Start Date:	Bushing 3/27/13	Start Qty: 60.00	*60*	Cust Item ID:
Required Date: Reference:	: 3/27/13	Req'd Qty: 60.00	*60*	Customer:
Approvals:	Process Pl	lan: _ ′	Date: Tooling:	Date:

QC8- Inspect parts - second check

Memo

Operation

Description

QC:_

Sequence ID/

120

Quality Control

120

Work Center ID

Cust Item I Customer:	D:						
	ate:		R	un	Start Stop	"!\]	R1* R2*
Tool ID	Tool#	Plan Code	Accept Qty	Reje Qty	ect ·	Reject Number	Insp. Stamp

Setup Start

Stop

130	Identify as per dwg & Stock Location:	0.00
130 Packaging Packaging	Memo Waeul	0.00
140	QC21- Final Inspection - Work Order Release	0.00
140 QC Quality Control	Memo	0.00

Date:

SPC (Y/N):

Set Up/

0.00

0.00

Run Hours

13-4-4

13/4/4

N B-04-4

Page 2

										DQA:	Da	te:	
NCR:	res / No	1			WORK ORDER NON-C	O	VFORM	MANCE / UPDAT		•		•	
								N 12	·	QA Closed:	Da	te:	Mary 2015
Work Orde	ar.	•			DISPOSITION		AGAINST DEPARTMENT/PROCESS						
Work Orde	=1.				Rework	1		Skid-tube C	rosstube		Water Jet		Engineering
Part No.				Scrap		1	 	Small Fab	Pro	d. Eng. Coor.		Quality	
					Use-as-is]	Therm	noforming	Finishing	Rec/Stor	e/Packaging		Other
NCR N	No				Work Order Update			Large Fab Co	omposite		Supplier		
Root				Descri	ption of work order update		Initial	Action		Sign &			
Cause	Date	Step	·Qty	(or Non-conformance	Ch	nief Eng	Description	on	Date	Verificatio	n	QC Inspector
Doc/Data													
Equip/Tooling													
Operator													
Material													
Setup													
Other								,					
Process			1										
Supplier													
Training													
Unapproved									14				
					F	AUL	T CATE	GORY					
Landi	ng Gear				General		1			1		_	1
	Bendin	g .			Bend	<u></u>	Grain			Ovalized		<u> </u>	Pressure/Forced
	Centre	Not Conce	ntric to (o/s	BOM/Route		Hardwa	re		Over/Under	tolerance		Temperature/Cure
	Cracks				Broken/Damaged	L	-l `	on Incomplete		Part Incorre		<u> </u>	Weld
	Crushe	d/Crimped			Burrs		-	ions Incomplete/Uncle	ear	Part Lost/Mi	ssing	L_	Wrong Stock Pulled
·	Cuffs				Contamination		Mainte			Part Moved			
	Heat Tr	eat			Countersink	L	Mislabe	led		Positioned V	=	_	1
	Inspect	ion Strip ir	1 Tube		Cut Too Short	L	Misread	l		Power Loss/	Surge	L_	Other
	Ripples	in Bend		ļ	Drill Holes		Offset						

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

March-28-13 12:55:02 PM

Work Order ID:

99143

Parent Item:

D4021-9

Parent Item Name:

Bushing

Start Date: 3/27/13

Required Date: 3/27/13

Start Qty: 60.00

Required Qty: 60.00

Comments:

IPP REV:A NEW ISSUE 09-11-23 JLM VERIFIED BY:DD

IPP Rev:B as per dwg REV.A

DD 10.02.22 verified by:EC IPP Rev:C as per dwg revB DD 10.04.20 verified by:EC

Qty per Kit Total Component Item ID/ Replacement Mfg/ Primary Last Route Unit of Qty on Qty Date Status Bin Measure Hand Item Name Issued Item ID Location Location Seq ID Qty Issued Purch Item M304R0.375 f Purchased No 64.7360 4.98 304 ROUND BAR 0.375

Location	Loc Qty	Loc Code	
MAT029	64.736		
119346	2.328		
120204	5.442		
121380	3.846		
→ D 123294	53.12		<u> </u>

Page 1

								DQA:	Date:			
NCR: Yes	s / No			WORK ORDER NON	-CONFOI	RMANCE / UF		QA Closed:	Date:			
Work Order				DISPOSITION		AGAINST DEPARTMENT/PROCESS						
Work Order:					¬	Clist Auto-	Cuanatuha		Water Jet	Engineering		
Part No.				Scrap Use-as-is	I			Prod. Eng. Coor. Qual				
NCR No.	•			Work Order Update] :	Large Fab	Composite		Supplier			
Root				Description of work order update	Initial	А	ction	Sign &				
Cause	Date	Step	Qty	or Non-conformance	Chief Er	ng Des	cription	Date	Verification	QC Inspector		
Doc/Data												
Equip/Tooling								·				
Operator		<u> </u>										
Material								ļ		•		
Setup												
Other												
Process												
Supplier												
Training												
Unapproved									<u> </u>			
					FAULT CAT	regory						

Broken/Damaged Instructions Incomplete/Unclear Part Lost/Missing Wrong Stock Pulled Crushed/Crimped. Burrs Contamination Part Moved Maintenance Cuffs Countersink Positioned Wrong Heat Treat Mislabeled Power Loss/Surge Other Inspection Strip in Tube Cut Too Short Misread Ripples in Bend Drill Holes Offset Torque Waves in Extrusion Drawing Out of Calibration Finish Out of Sequence Turning Sequence Folio Outside Dimensions Wave/Twist in Tube

Grain

Hardware

Inspection Incomplete

Pressure/Forced

Weld

Temperature/Cure

Ovalized

Part Incorrect

Over/Under tolerance

General

Bend

BOM/Route

Landing Gear

Bending

Cracks

Centre Not Concentric to O/S

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DART AEROSPACE LTD	Work Order:	19143
Description: Bushing	Part Number:	D4021-9
Inspection Dwg: D4021 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing		Actual			Method of	
Dimension	Tolerance	Dimension	Accept	Reject	Inspection	Comments
Ø0.191	+0.005/-0.001	,191 .370	V		PiN G	
0.38	+/-0.030	. 370			VERN	140-01
0.75	+/-0.030	,746			15	11
	_					
						
		-				
·*·	-					
	1		DAG			

Measured by: PD	Audited by: 13	Preliminary Approval:
Date: 13/64/63	Date: 13 4 - 4	Date:

Rev	Date	Change	Revised by		Approved
Α	10.06.08	New Issue	KJ (KX	
•				T	

Ø0.191 -- Ø0.38 5.00 R0.50 4 PL 2.25 R0.10 2 PL 0.63 +0.00 45° 2 PL 0.813 ==== С R1.125 2.56 REF Ø0.194 Ç 0.75 R1.438 R1.75 ---0.63^{+0.00} **D4021-9 BUSHING** 2.500 **D4021-7 HOOP** NOTES: 1) MATERIAL-7: 304/316 STAINLESS STEEL BAR, PER ASTM A276 REF DART SPEC M304B MP -9: 304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 REF DART SPEC M304R DESIGN AJS DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA 2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT -7: 0.80 lbs
-9: 0.02 lbs DRAWN JPH CHECKED DRAWING NO. REV. B D4021 MFG. APPR. SHEET 3 OF 3 WO-99143 TITLE APPROVED SCALE MISC PARTS - 350 BASKET DE APPR. COPYRIGHT © 2010 BY DART AEROSPACE LTD
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